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D4776-1

Job Sheet 199875



Part No: D4776-1

Job Qty: 30 pcs

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/3/19

Job Tracking No:

Due Date: 10/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4776 REV.E IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	30 pcs		10/8/19	0.54	15.96	Doosan - 1		14/10/06
105	QC 2	30 pcs		10/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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DAS
65
9-89

111 QC 8 30 10/8/19 0.00 0.00
pcs

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

19/10/06

B-A 19-10-07

112 Handfinish - 1-1 Chemical- 30 10/8/19 0.00 0.86
B4B pcs

Handfinish - 1 - 1 -
B4BHandfinish - 1 - 2 -
B4BHandfinish - 1 - 3 -
B4BHandfinish - 1 - 4 -
B4BHandfinish - 1 - 5 -
B4BHandfinish - 1 - 6 -
B4BHandfinish - 1 - 7 -
B4BHandfinish - 1 - 8 -
B4BHandfinish - 1 - 9 -
B4BHandfinish - 1 - 10 -
B4BHandfinish - 1 - 11 -
B4BHandfinish - 1 - 12 -
B4BHandfinish - 1 - 13 -
B4BHandfinish - 1 - 14 -
B4BHandfinish - 1 - 15 -
B4BHandfinish - 1 - 16 -
B4B

A OCT 08 2019

						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
						QC 7 - 10	
113 QC 7	30 pcs	10/8/19	0.00	0.00		QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
115 Powdercoat - 1 White Gl(A)- B4B	30 pcs	10/8/19	0.00	0.35		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
116 QC 3	30 pcs	10/8/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	

Bl 19-10-9.

Bl 19-10-9.

START: 10:35 O.U.T. 320° FINISH: 11:05

9/3/2019

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						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	DAS
						QC 3 - 40	NOT 0 0 2019 40
						QC 3 - 19	9-89
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						Packaging 3 - 1 - B4B	
130 Packaging 3-1 - Stock - B4B	30 pcs	10/8/19	0.00	0.00		Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	Pc still
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 -	

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				B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	30 pcs	10/8/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89 OCT 10 2019

Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB167 Rev: AA & Dwg D4776 Rev: E 2 -Deburr per dwg D4776
 Descriptions: 105 - (QC2- Inspect parts off machine FAI/FAIB)
 111 - (QC8- Inspect parts - second check)
 112 - (Chemical Conversion Coat per QSI005 4.1)
 113 - (QC7-Inspect Chemical Conversion Coat)
 115 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) MASK .403 ROUND SECTION AS PER DWG START TIME:
 OVEN TEMPERATURE: _____ FINISH TIME: _____
 116 - (QC3- Inspect Part Finish)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	10.2300 ft (.341 ea)	100-Doosan - 1	5177885

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R1.500	10	10	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches $\pm$ 0.030	0.910 0.850	.88	
2	Basket Strut Clevis	0.438Inches $\pm$ 0.010	0.448 0.428	.439	
3	Basket Strut Clevis	0.380Inches $\pm$ 0.030	0.410 0.350	.385	
4	Basket Strut Clevis	0.625Inches $\pm$ 0.010	0.635 0.615	.625	
5	Basket Strut Clevis	1.750Inches $\pm$ 0.030	1.780 1.720	1.75	
6	Basket Strut Clevis	3.500Inches $\pm$ 0.030	3.530 3.470	3.501	
7	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	45	Angle
8	Basket Strut Clevis	0.030Inches $\pm$ 0.030	0.060 0.000	.029	
9	Basket Strut Clevis	0.060Inches $\pm$ 0.030	0.090 0.030	1/6	Radius
10	Basket Strut Clevis	0.196Inches $\pm$ 0.006 - 0.001	0.202 0.195	.1985	Diameter
11	Basket Strut Clevis	0.261Inches $\pm$ 0.006 - 0.001	0.267 0.260	.262	Diameter
12	Basket Strut Clevis	0.410Inches $\pm$ 0.030	0.440 0.380	.41	Radius RAD gauge
13	Basket Strut Clevis	1.130Inches $\pm$ 0.030	1.160 1.100	1.13	
14	Basket Strut Clevis	0.188Inches $\pm$ 0.010	0.198 0.178	.188	
15	Basket Strut Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	.189	
16	Basket Strut Clevis	0.500Inches $\pm$ 0.030	0.530 0.470	.504	
17	Basket Strut Clevis	0.750Inches $\pm$ 0.010	0.760 0.740	.75	
18	Basket Strut Clevis	0.403Inches $\pm$ 0.000 - 0.005	0.403 0.398	.4005	Diameter
19	Basket Strut Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	1/8	Radius
20	Basket Strut Clevis	0.750Inches $\pm$ 0.010 - 0.000	0.760 0.750	.755	
21	Basket Strut Clevis	0.160Inches $\pm$ 0.030	0.190 0.130	.166	
22	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	45	Angle

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS													
		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality							
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)											
Description Work Order Deviation				Disposition													
				Completed By													
				Lead hand / Supervisor													
				QC / QA Coordinator													
Root Cause				FAULT CATEGORY													
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong							
				Bending		Misaligned/off center		Folio/Program		Outside Tolerance							
				Crushing		BOM/Route		Grain Direction		Drawing							
				Cracks		Broken/Damage/Defect		Weld		Finish							
				Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing							
				Marks/Chatter		Drill Holes		Out of Sequence		Misread							
				Mislabeled		Fit/Function		Off-set/Set-up									
				Other/Details:													